

Date: Monday, 26/05/2008 1:11:56 PM  
 User: Linda Lacelle

## Process Sheet

OK

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : END FITTING ASS'Y RH
Job Number : 39482	
Estimate Number : 13343	
P.O. Number :	Part Number : D3763044
This Issue : 26/05/2008 S.O. No. :	Drawing Number : D3763 PROTO
Prsht Rev. : NC	Project Number : IA0004 08.05.20
First Issue : 26/05/2008 Type : R & D LG FAB	Drawing Revision : PROTO
Previous Run :	Material :
Written By : <u>M 08/05/20</u>	Due Date : 02/06/2008 Qty: <u>2</u> Um: Each
Checked & Approved By :	
Comment : Est Rev:A 08-05-20 new issue DD verified by:	

## Additional Product

PROTOTYPE

Job Number:



FOR ENGINEERING USE ONLY

Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
 Pick Packing Kit

2.0	D37631	End Fitting
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Comment: Qty.: 4 2.0000 Each(s)/Unit Total : 2 0000 Each(s)  
 End Fitting  
 batch: B39483 CP 08.05.29

(X2)

3.0	D37636	Tube
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(X2)

Comment: Qty.: 2 1.0000 Each(s)/Unit Total : 2 0000 Each(s)  
 Tube  
 batch: B39469 CP 08.05.29

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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(X2)

Comment: LARGE FABRICATION RESOURCE 1.  
 1-make a 0.063" chamfer on D3763-1 fitting before ass'y

2-assemble as per dwg D3763 using locating pin DT 9014  
 \*\*\*\*\*look at dwg before assembling parts (RH) \*\*\*\*\*

3-weld as per dwg D3763 QSI004  
 Alum. rod Batch: M106834

CP 08.05.29

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Drawing Name: END FITTING ASS'Y RH

Job Number: 39482

Part Number: D3763044

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

2008/05/29 (2)

6.0

QC5

INSPECT WORK TO CURRENT STEP



**ENGINEERING  
APPROVAL**



PTO

Comment: INSPECT WORK TO CURRENT STEP

PE 20.05.30/

7.0

PACKAGING 1

PACKAGING RESOURCE #1



**FOR ENGINEERING USE ONLY**



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock  
Location: \_\_\_\_\_

N/A.

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2008.06.02 Plompee

Job Completion

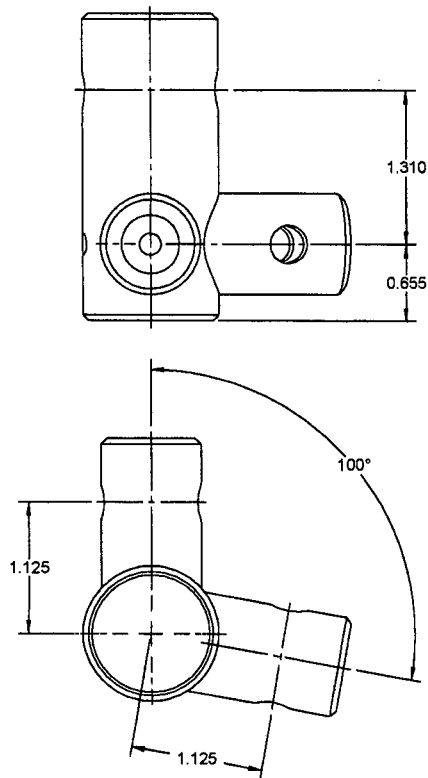


Charge to W/O # 0096

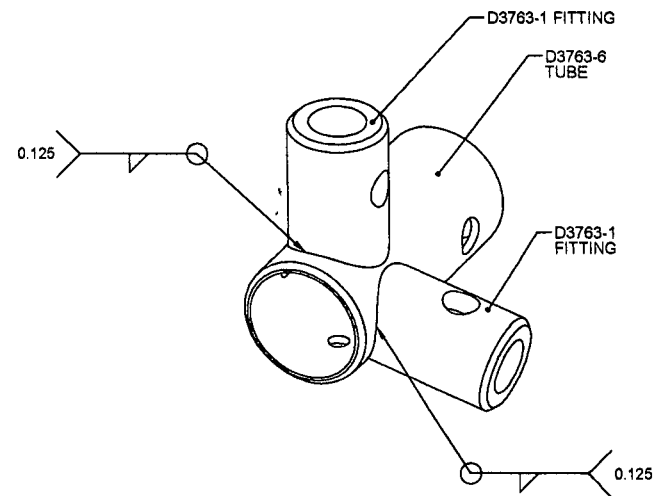
2008-06-11

S.S. Chemical conversion cadt ASI 005 4.1  
S.S.I DC3 Inspect Chemical conversion

M. J. 08/05/22  
# 08-05-29  
②



**D3763-044 END FITTING ASSY. RH**



**PROTOTYPE**

*PH 08.05.30*

**NOTES:**

- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.05 lbs
  - 8) WELD: PER DART QSI 004
- chemical conversion cobit QSI 005 4.1 PH 08.05.30*

DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3763	SHEET 3 OF 7
APPROVED		TITLE	SCALE
DE APPR.		END FITTING	1:1
DATE	08.05.22	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	